

GrooveLine

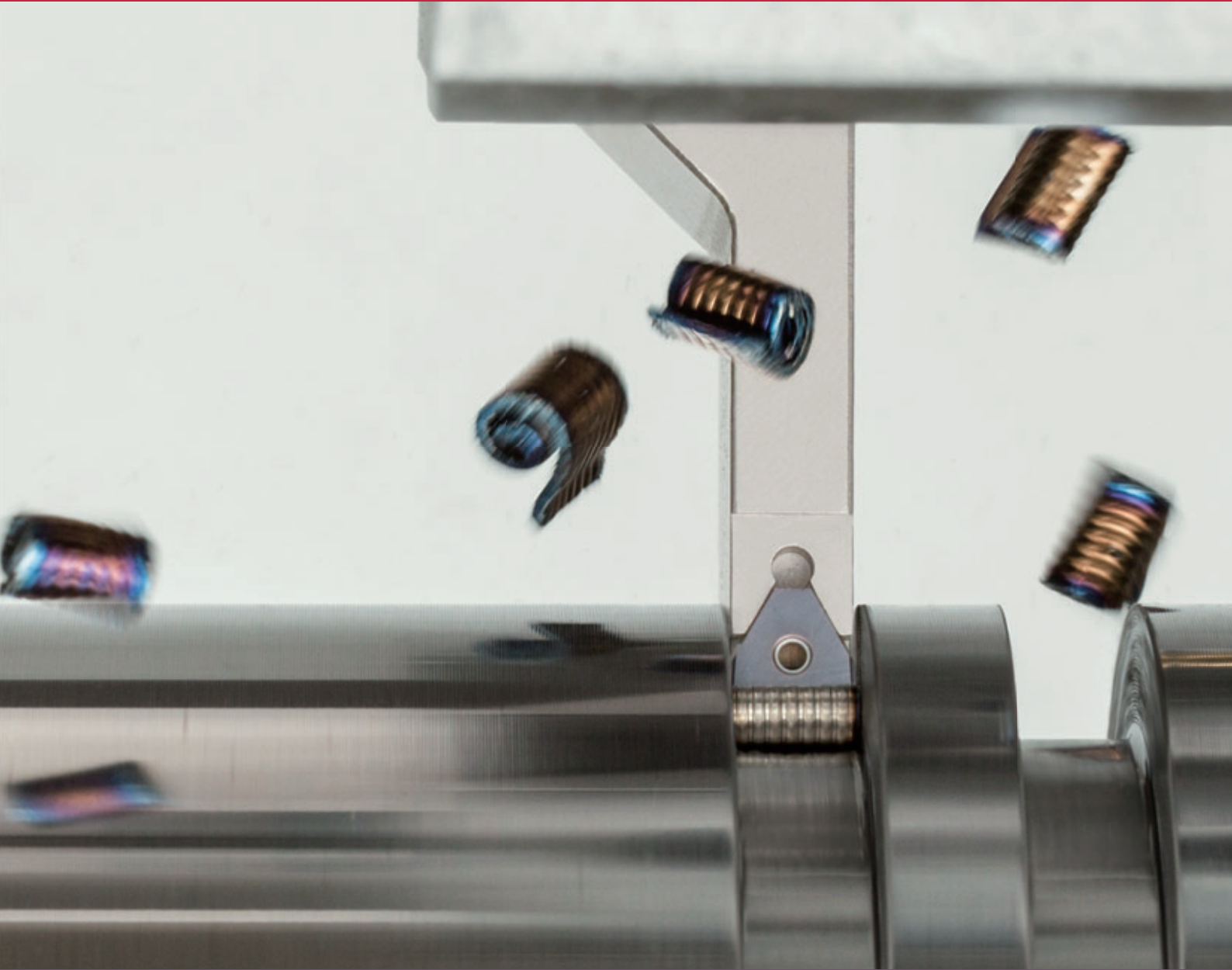
TUNG<sup>HEAVY</sup>GROOVE

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Tungaloy Report No. 427-G

TUNGHEAVYGROOVE

Effectively **reduces machining time!**



Member IMC Group  
**Tungaloy**



ACCELERATED MACHINING



GrooveLine

# TUNG<sup>HEAVY</sup>GROOVE

TUNGALOY

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**Unique system** for wide grooving and wide profile grooving

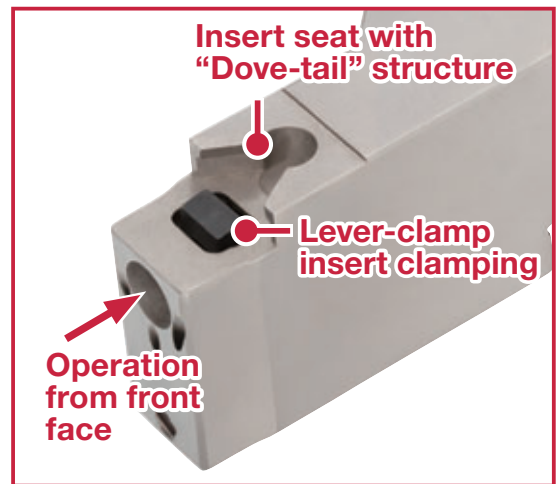
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## Efficiently **reduces machining time** of wide width grooving and forming!

Effectively reduces the number of passes or machining time of complex profiles!

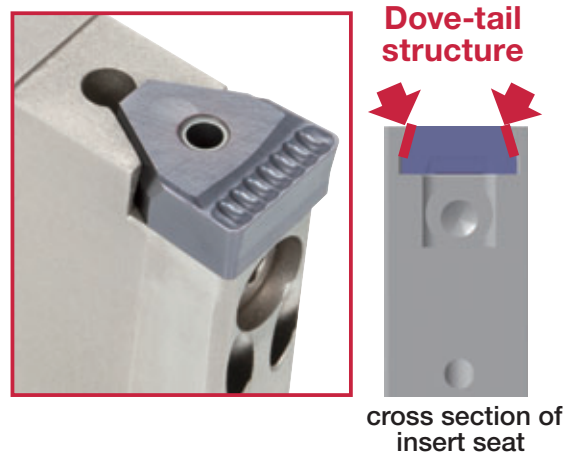
### Easy insert clamp operated from front face

Indexing can be operated from front face of toolholder, reducing insert changing time and machine downtime.



### Highly rigid lever-clamping provides stable grooving

Dove-tail structure prevents insert movement during wide grooving operations.



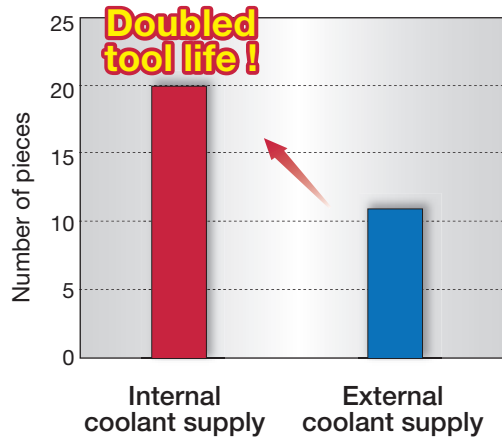
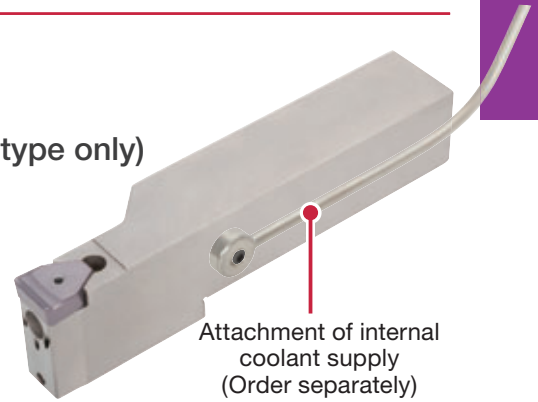
### Open tool design, provides a clear path for chip evacuation

Excellent chip shape, due to the dimple shape chipbreaker design. Large rake angle reduces cutting forces.



## Internal coolant supply is available (For FPGR type only)

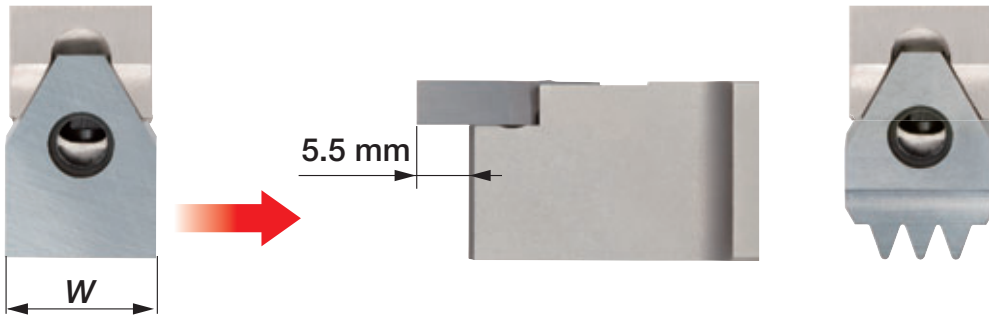
Internal coolant supply can be added on the FPGR/L type grooving toolholders. 2 or 3 coolant holes on front face (depending on toolholder size). Coolant is supplied directly to the cutting edge, reducing flank wear and improving tool life, as well as improves chip control.



Insert : PSGM10-08  
 Grade : AH725  
 Work material : SCM415  
 Cutting speed :  $V_c = 100$  m/min  
 Feed :  $f = 0.3$  mm/rev  
 Groove depth :  $d = 20$  mm

## Profile grooving inserts and tools

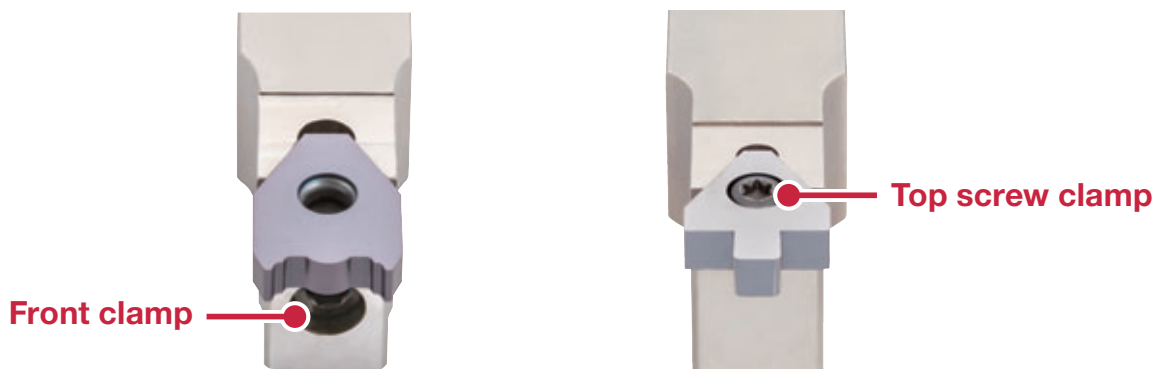
- Inserts are supplied in width (W) 10 - 25 mm.
- The insert length is extended for profile shapes up to 5.5 mm depth.



## Two styles of tools are available!

■ Lever lock type

■ Screw on type



## Inserts

### ■ For wide grooving



	Groove width $W^*$ (mm)	Cat. No.	Grades		Dimensions (mm)		
			Coated		$L$	$s$	$r_{\epsilon}$
			AH725				
	10	PSGM10-08	●		11	4.0	0.8
	15	PSGM15-15	●		15	5.0	1.5
	20	PSGM20-20	●		22	6.5	2.0
	25	PSGM25-20	●		22	6.5	2.0

\* Tolerance of groove width  $W = 10: \pm 0.08, W \geq 15: \pm 0.1$

### ■ Blanks for wide profile grooving\*



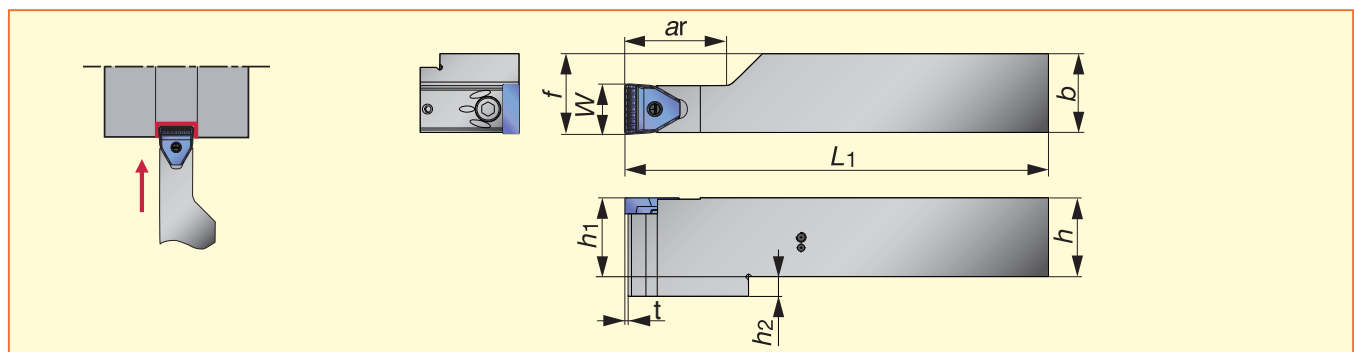
	Groove width $W \pm 0.025$ (mm)	Cat. No.	Grades		Dimensions (mm)	
			Carbide		$L$	$s$
			UX30	TH10		
	10.2	PSGB10	●	●	18	4.0
	15.2	PSGB15	●	●	20	5.0
	20.2	PSGB20	●	●	27	6.5
	25.2	PSGB25	●	●	27	6.5

\*Stocked products are blanks (semi-finished) for formed inserts

## Toolholders

### FPG R

### Lever lock type, for external wide grooving



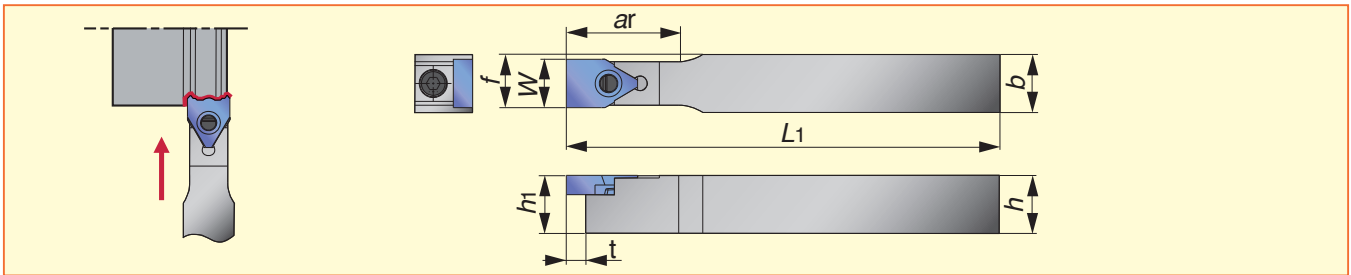
Groove width $W$ (mm)	Cat. No.	Stock	Max. groove depth $ar$ (mm)		Dimensions (mm)								Clamping screw (*) Insert	Lever Spring Wrench	
			PSGB	PSGM	$h_1$	$b$	$h$	$L_1$		$f$	$h_2$	$t$			
								PSGB	PSGM			PSGB			PSGM
10	FPGR2525M-10T20	●	25	20	25	25	25	155	150	25.5	-	5.5	0.5	PSG*10	FCS3 FCL4 BP-5 P-2.5
10	FPGR3232P-10T36	●	41	36	32	32	32	175	170	32.5	-	5.5	0.5	PSG*10	FCS3 FCL4 BP-5 P-2.5
15	FPGR2525M-15T20	●	25	20	25	25	25	155	150	25.5	-	5.5	0.5	PSG*15	FCS3 FCL4 BP-5 P-2.5
15	FPGR3232P-15T40	●	45	40	32	32	32	175	170	32.5	-	5.5	0.4	PSG*15	FCS3 FCL4 BP-5 P-2.5
20	FPGR3232P-20T40	●	45	40	32	32	32	175	170	32.5	8	5.5	0.4	PSG*20	FCS6 FCL8 BP-9 P-5
20	FPGR4040R-20T50	●	55	50	40	40	40	205	200	40.5	8	5.5	0.4	PSG*20	FCS6 FCL8 BP-9 P-5
25	FPGR3232P-25T40	●	45	40	32	32	32	175	170	32.5	8	5.5	0.4	PSG*25	FCS6 FCL8 BP-9 P-5
25	FPGR4040R-25T50	●	55	50	40	40	40	205	200	40.5	8	5.5	0.4	PSG*25	FCS6 FCL8 BP-9 P-5

(\*) Can be used with both wide grooving and profile grooving inserts

● : Stocked items

## FPGN

Lever lock type, for external wide profile grooving

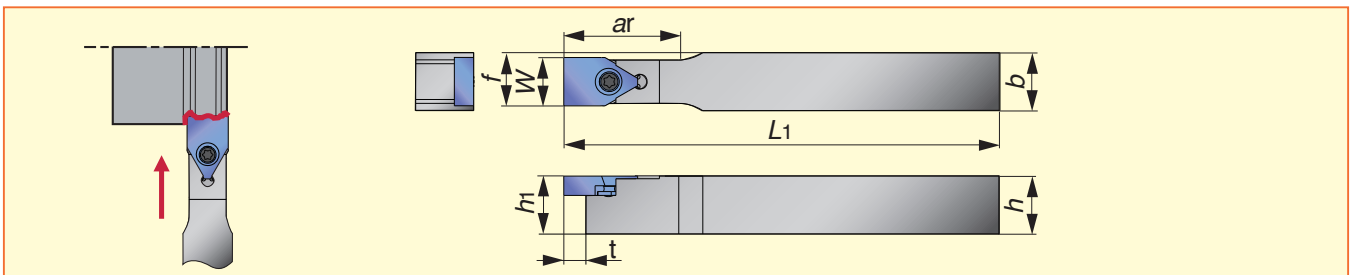


Groove width W (mm)	Cat. No.	Stock	Max. groove depth ar (mm)		Dimensions (mm)							Insert	Clamping screw	Lever	Spring	Wrench	
			PSGB	PSGM	h <sub>1</sub>	b	h	L <sub>1</sub>		f	t						
								PSGB	PSGM		PSGB						PSGM
10	FPGN1212X-10T20	●	25	20	12	12	12	125	120	11.0	5.5	0.5	PSG*10	FCS3	FCL4	BP-5	P-2.5
10	FPGN1616X-10T20	●	25	20	16	16	16	125	120	13.0	5.5	0.5	PSG*10	FCS3	FCL4	BP-5	P-2.5
10	FPGN2020K-10T20	●	25	20	20	20	20	130	125	15.0	5.5	0.5	PSG*10	FCS3	FCL4	BP-5	P-2.5
15	FPGN1616X-15T25	●	30	25	16	16	16	125	120	15.5	5.5	0.4	PSG*15	FCS3	FCL4	BP-5	P-2.5
15	FPGN2020K-15T25	●	30	25	20	20	20	130	125	17.5	5.5	0.4	PSG*15	FCS3	FCL4	BP-5	P-2.5
20	FPGN2020K-20T32	●	37	32	20	20	20	130	125	20.0	5.5	0.4	PSG*20	FCS6	FCL8	BP-9	P-5
20	FPGN2525M-20T32	●	37	32	25	25	25	155	150	22.5	5.5	0.4	PSG*20	FCS6	FCL8	BP-9	P-5
25	FPGN2525M-25T36	●	41	36	25	25	25	155	150	25.0	5.5	0.4	PSG*25	FCS6	FCL8	BP-9	P-5

(\*1) Can be used with both wide grooving and profile grooving inserts

## SPGN

Screw on type, for external wide profile grooving



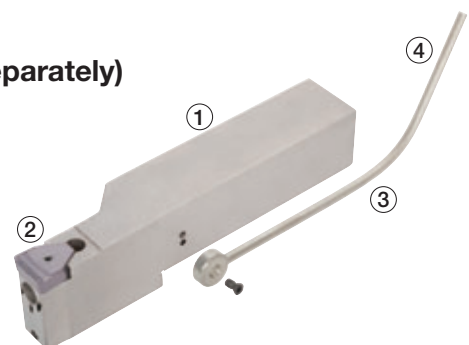
Groove width W (mm)	Cat. No.	Stock	Max. groove depth ar(mm)	Dimensions (mm)					Insert	Clamping screw	Wrench	
				h <sub>1</sub>	b	h	L <sub>1</sub>	f				t
10	SPGN1212X-10T20	●	25	12	12	12	125	11.0	5.5	PSGB10	CSTB-3L081	T-9F
10	SPGN1616X-10T20	●	25	16	16	16	125	13.0	5.5	PSGB10	CSTB-3L081	T-9F
10	SPGN2020K-10T20	●	25	20	20	20	130	15.0	5.5	PSGB10	CSTB-3L081	T-9F
15	SPGN1616X-15T25	●	30	16	16	16	125	15.5	5.5	PSGB15	CSTB-4	T-15F
15	SPGN2020K-15T25	●	30	20	20	20	130	17.5	5.5	PSGB15	CSTB-4	T-15F
20	SPGN2020K-20T32	●	37	20	20	20	130	20.0	5.5	PSGB20	CSTB-5	T-20F
20	SPGN2525M-20T32	●	37	25	25	25	155	22.5	5.5	PSGB20	CSTB-5	T-20F
25	SPGN2525M-25T36	●	41	25	25	25	155	25.0	5.5	PSGB25	CSTB-5	T-20F

(\*2) Can be used with profile grooving inserts, only

● : Stocked items

### ■ Spare parts for internal coolant supply attachment (Order separately)

No.	Parts name	Designation	Note
①	Body	FPGR...	-
②	Insert	PSGM...	-
③	Coolant supply attachment	SGCU 341	-
④	Connector	Commercial items can be used	G 1/8 thread NPT 1/8 thread



## Grades

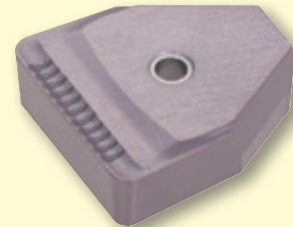


Wide grooving insert PSGM type

### AH725



Steel



Recommended grade for grooving.

PVD coated grade featuring an excellent balance of strength and wear resistance.

- The combination of micro grain substrate and flash-coating with high heat resistance provides incredible performance in wide grooving.



Forming insert PSGB type

### UX30

Uncoated



Steel



Stainless

### TH10

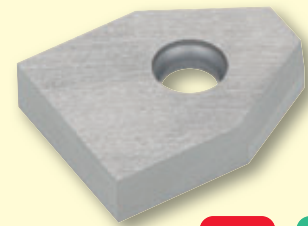
Uncoated



Cast Iron

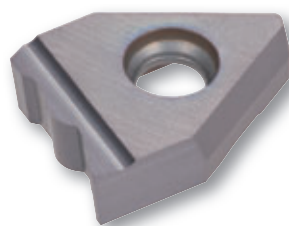


Non-ferrous



Cemented carbide grade with high fracture resistance.

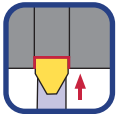
Carbide grade for general purpose with excellent wear resistance.



Specially tailored profile insert

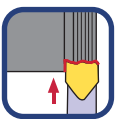


## Standard cutting conditions



### Wide grooving

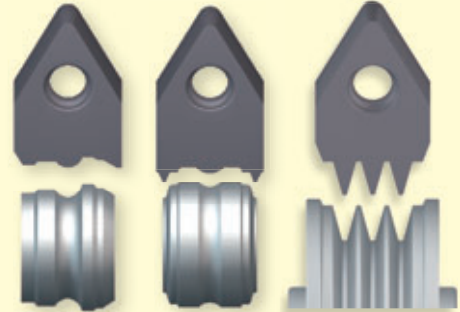
ISO	Workpiece materials	Hardness (HB)	Grade	Cutting speed Vc (m/min)
<b>P</b>	Alloy steels (SCM440 / 42CrMo4 etc.)	< 300	<b>AH725</b>	50 - 180
	Alloy steels (SCM440 / 42CrMo4 etc.)	< 300	<b>UX30</b>	50 - 120
PSGM type insert	Groove width: W (mm)			
	10	15	20	25
Feed: f (mm/rev)	0.2 - 0.4	0.2 - 0.4	0.3 - 0.5	0.3 - 0.5



### Forming

ISO	Workpiece materials	Hardness (HB)	Grade	Cutting speed Vc (m/min)
<b>P</b>	Steels (S45C / C45 etc.)	< 200	<b>UX30</b>	50 - 150
	Alloy steels (SCM440 / 42CrMo4 etc.)	< 300	<b>UX30</b>	50 - 120
<b>M</b>	Stainless steels (SUS303 / X10CrNiS18-9 etc.)	< 200	<b>UX30</b>	50 - 120
<b>K</b>	Grey cast irons (FC250 / 250 etc.)	-	<b>TH10</b>	50 - 150
	Ductile cast irons (FCD450 / 450-10S etc.)	-	<b>TH10</b>	50 - 120
<b>N</b>	Aluminium alloy (Si < 12% etc.)	-	<b>TH10</b>	100 - 500

- Custom shaped inserts can be supplied on customer's request, according to the designated final shape on part drawing.
- Semi-finished blanks PSGB types are offered for purchase.



## Practical examples

Workpiece type		Machine part	Engine part
Toolholder		FPGR3232P-10T36	FPGR3232P-10T36
Insert		PSGM10-08 (W = 10 mm)	PSGM10-08 (W = 10 mm)
Grade		AH725	AH725
Workpiece material		SCM415	Cast steel
Cutting conditions	Cutting speed: Vc (m/min)	110	65
	Feed : f (mm/rev)	0.3	0.37
	Number of pass for 1 groove	2	3
	Method of machining	Grooving	Grooving
	Coolant	Wet	Wet
Results		<p><b>TUNGROOVE Competitor</b></p> <p>By using wider grooving tool, cycle times can be reduced to 1/3. 15 times longer tool life is achieved due to AH725 grade with high wear resistance.</p>	<p><b>TUNGROOVE Competitor</b></p> <p>Higher cutting conditions and continuous feeds without pecking cycles, drastically reduce machining times.</p>



## Tungaloy Corporation (Head office)

11-1 Yoshima-Kogyodanchi  
Iwaki-city, Fukushima, 970-1144 Japan  
Phone: +81-246-36-8501  
Fax: +81-246-36-8542  
www.tungaloy.co.jp

## Tungaloy America, Inc.

3726 N Ventura Drive  
Arlington Heights, IL 60004, U.S.A.  
Phone: +1-888-554-8394  
Fax: +1-888-554-8392  
www.tungaloyamerica.com

## Tungaloy Canada

432 Elgin St. Unit 3  
Brantford, Ontario N3S 7P7, Canada  
Phone: +1-519-758-5779  
Fax: +1-519-758-5791  
www.tungaloy.co.jp/ca

## Tungaloy de Mexico S.A.

C Los Arellano 113,  
Parque Industrial Siglo XXI  
Aguascalientes, AGS, Mexico 20290  
Phone: +52-449-929-5410  
Fax: +52-449-929-5411  
www.tungaloy.co.jp/mx

## Tungaloy do Brasil Ltda.

Avd. Independencia N4158 Residencial Flora  
13280-000 Vinhedo, São Paulo, Brasil  
Phone: +55-19-38262757  
Fax: +55-19-38262757  
www.tungaloy.com/br

## Tungaloy Germany GmbH

An der Alten Ziegelei 1  
D-40789 Monheim, Germany  
Phone: +49-2173-90420-0  
Fax: +49-2173-90420-19  
www.tungaloy.de

## Tungaloy France S.A.S.

ZA Courtaboeuf - Le Rio  
1 rue de la Terre de feu  
F-91952 Courtaboeuf Cedex, France  
Phone: +33-1-6486-4300  
Fax: +33-1-6907-7817  
www.tungaloy.fr

## Tungaloy Italia S.r.l.

Via E. Andolfato 10  
I-20126 Milano, Italy  
Phone: +39-02-252012-1  
Fax: +39-02-252012-65  
www.tungaloy.it

## Tungaloy Czech s.r.o.

Turanka 115  
CZ-627 00 Brno, Czech Republic  
Phone: +420-532 123 391  
Fax: +420-532 123 392  
www.tungaloy.cz

## Tungaloy Ibérica S.L.

C/Miquel Servet, 43B, Nau 7  
Pol. Ind. Bufalvent  
ES-08243 Manresa (BCN), Spain  
Phone: +34 93 113 1360  
Fax: +34 93 876 2798  
www.tungaloy.es

## Tungaloy Scandinavia AB

Bultgatan 38  
442 40 Kungälv, Sweden  
Phone: +46-462119200  
www.tungaloy.se

## Tungaloy Rus, LLC

36-D Harkovsky Lane  
308009 Belgorod, Russia  
Phone: +7 4722 24 00 07  
Fax: +7 4722 24 00 08  
www.tungaloy.co.jp/ru

## Tungaloy East LLC

Stachek str., h.4, office 2, Ekaterinburg,  
620017, Russia  
Phone: +7-343-389-13-22  
Fax: +7-343-278-94-35  
www.tungaloy.co.jp/rue

## Tungaloy Polska Sp. z o.o.

ul. Genewska 24  
03-963 Warszawa, Poland  
Phone: +48-22-617-0890  
Fax: +48-22-617-0890  
www.tungaloy.co.jp/pl

## Tungaloy U.K. Ltd

The Technology Centre,  
Wolverhampton Science Park  
Glaisher Drive, Wolverhampton  
West Midlands WV10 9RU, UK  
Phone: +44 121 4000 231  
Fax: +44 121 270 9694  
www.tungaloy.co.jp/uk  
salesinfo@tungaloyuk.co.uk

## Tungaloy Hungary Kft

Erzsébet királyné útja 125  
H-1142 Budapest, Hungary  
Phone: +36 1 781-6846  
Fax: +36 1 781-6866  
www.tungaloy.co.jp/hu  
info@tungaloytools.hu

## Tungaloy Turkey

Dudullu.OSB 4. Cad No:4  
34776 Umraniye Istanbul, TURKEY  
Phone: +90 216 540 04 67  
Fax: +90 216 540 04 87  
www.tungaloy.com.tr  
info@tungaloy.com.tr

## Tungaloy Benelux b.v.

Tjalk 70  
NL-2411 NZ Bodegraven, Netherlands  
Phone: +31 172 630 420  
Fax: +31 172 630 429  
www.tungaloy-benelux.com

## Tungaloy Croatia

Josipa Kozarca 4  
10432 Bregana, Croatia  
Phone: +385 1 3326 604  
Fax: +385 1 3327 683  
www.tungaloy.hr

## Tungaloy Cutting Tool (Shanghai) Co.,Ltd.

Rm No 401 No.88 Zhabei  
Jiangchang No.3 Rd  
Shanghai 200436, China  
Phone: +86-21-3632-1880  
Fax: +86-21-3621-1918  
www.tungaloy.co.jp/tcts

## Tungaloy Cutting Tool (Thailand) Co.,Ltd.

Interlink tower 4th Fl.  
1858/5-7 Bangna-Trad Road  
km.5 Bangna, Bangna, Bangkok 10260  
Thailand  
Phone: +66-2-751-5711  
Fax: +66-2-751-5715  
www.tungaloy.co.th

## Tungaloy Singapore (Pte.), Ltd.

62 Ubi Road 1, #06-11 Oxley BizHub 2  
Singapore 408734  
Phone: +65-6391-1833  
Fax: +65-6299-4557  
www.tungaloy.co.jp/tspl

## Tungaloy Vietnam

Unit 18, 4th Fl. Saigon Centre Building  
65 Le Loi Blvd.  
Dist 1, Ho Chi Minh City, Vietnam  
Phone: +84-8-3827-0201  
Fax: +84-8-3827-0203  
www.tungaloy.co.jp/tspl

## Tungaloy India Pvt. Ltd.

Indiabulls Finance Centre,  
Unit # 902-A, 9th Floor,  
Tower 1, Senapati Bapat Marg,  
Elphinstone Road (West),  
Mumbai-400013, India  
Phone: +91-22-6124-8804  
Fax: +91-22-6124-8899  
www.tungaloy.co.jp/in

## Tungaloy Korea Co., Ltd

#1312, Byucksan Digital Valley 5-cha  
Beotkkot-ro 244, Geumcheon-gu  
153-788 Seoul, Korea  
Phone: +82-2-2621-6161  
Fax: +82-2-6393-8952  
www.tungaloy.co.jp/kr

## Tungaloy Malaysia Sdn Bhd

50 K-2, Kelana Mall, Jalan SS6/14  
Kelana Jaya, 47301  
Petaling Jaya, Selangor Darul Ehsan  
Malaysia  
Phone: +603-7805-3222  
Fax: +603-7804-8563  
www.tungaloy.com.my

## Tungaloy Australia Pty Ltd

PO Box 2232, Rowville,  
Victoria 3178, Australia  
Phone: +61-3-9755-8147  
Fax: +61-3-9755-6070  
www.tungaloy.com.au

## PT. Tungaloy Indonesia

Kompleks Grand Wisata Block AA-10 No.3-5  
Cibitung  
Bekasi 17510, Indonesia  
Phone: +62-21-8261-5808  
Fax: +62-21-8261-5809  
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